

Work Order ID 54382

December 8, 2009 11:28:28 AM



Page 1

Item ID: D3766-2 Accept Setup Start

Revision ID: Stop

Item Name: Front Rail, RH

Start Date: 08/12/2009 Start Qty: 10.00 Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 10.00 Customer:

Reference:

Approvals: Process Plan: Date: 09-12-08 Tooling: Date: Run Start

QC: Date: SPC (Y/N): Date: Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3766	Rev B

100	Small Fab	0.00							
	Small Fab	0.00							
Small Fab	Memo								
	1-cut tube to length as per dwg D3766□2-drill holes thru to finish size as per dwg D3766 using DT9413,,drill holes labelled #2□3- deburr								

110	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
Quality Control	Memo								

120	Chemical Conversion Coat per QS1005 4.1	0.00							
	HandFinish	0.00							
Hand Finishing	Memo								

10X

M.L 10/01/06

⇒ 81060608

10 X

BR 10-01-11 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3766-2 PAR #: N/A Fault Category: Small FAB NCR: Yes No DQA: Yes Date: 10-01-12
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 10/01/26

NCR: <u>54382</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/09	100	Part 11 After drilling it was found on Qty x4 parts that the holes at section EE do not align with the sleeve D3766-3.	<i>[Signature]</i>	- Parts do not align so Scrap Qty x4 and replace DA <u>113511</u>	M-12 10/01/05	S 10/01/05	<i>[Signature]</i>	S 09/12/07
		2. Improper training on Drill Sig. Lack of communication	<i>[Signature]</i>	- Lead hand must train all employees in cell to be able to work with all Sgs; record on Job training logs; attach ref copy.	S 10/01/12	S 10/01/12	<i>[Signature]</i>	S 09/12/09

NOTE: Date & initial all entries

Work Order ID 54382

December 8, 2009 11:28:28 AM



Page 2

Item ID: D3766-2

Accept



Setup Start



Revision ID:

Item Name: Front Rail, RH

Stop



Start Date: 08/12/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-1-11 8/104

140

Identify as per dwg & Stock Location: 254

0.00



Packaging

Memo

0.00

Packaging

10-1-12 5/100

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/12 MF 10-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 8, 2009 11:28:32 AM

Page 1

Work Order ID: 54382



Parent Item: D3766-2



Parent Item Name: Front Rail, RH

Start Date: 08/12/2009

Required Date: 16/12/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.000W.188		Purchased	No			100	f	56.1948	29.3968			

6061T6 RD TUBE 1.00 X .188W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	56.1947542	
109041	1.03	
112529	53.5647542	
18101	1.6	

M113511

M-12 10/01/05

10X



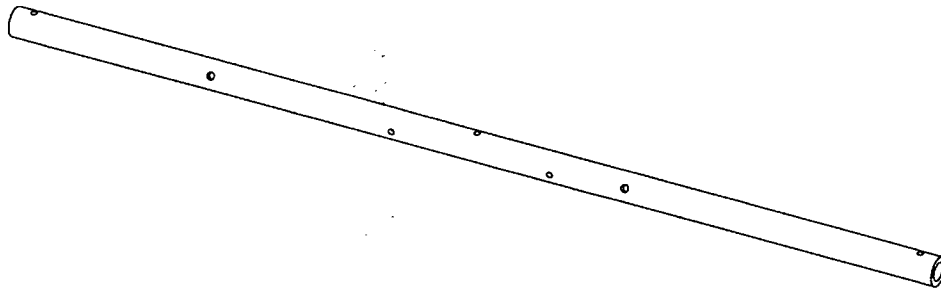
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

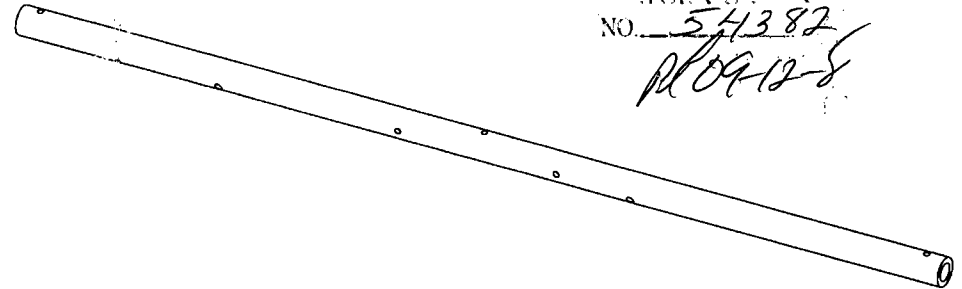
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

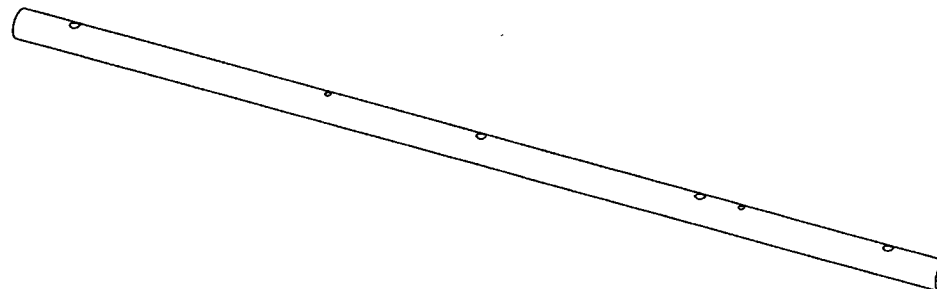
NOTE: Date & initial all entries



D3766-1 FRONT RAIL, LH



D3766-2 FRONT RAIL, RH



D3766-3 REAR RAIL

NO. 541382

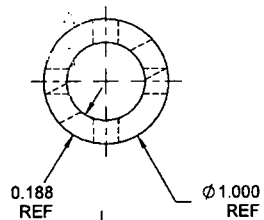
110912-8

08.07.10

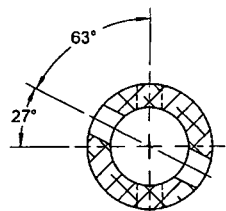
NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER VVV-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3766-1, 1.55 lbs
D3766-2, 1.55 lbs
D3766-3, 1.55 lbs

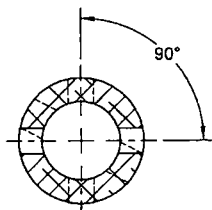
B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3766	SHEET 1 OF 4
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DE APPR.	HS	RAIL	NTS
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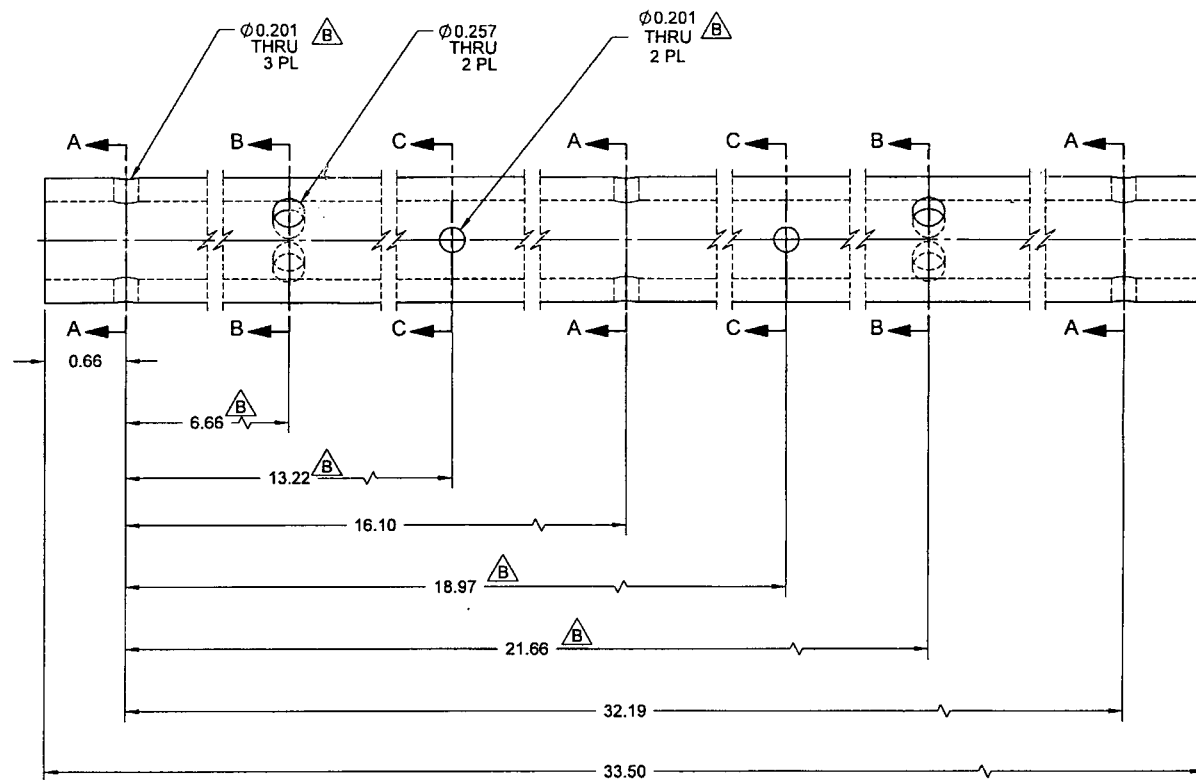
SECTION A-A



SECTION B-B



SECTION C-C

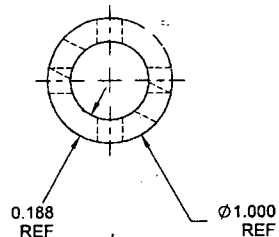


D3766-1 FRONT RAIL, LH

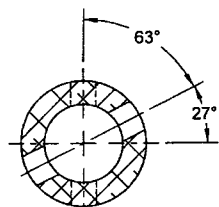
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08-07-10

W/O 54352

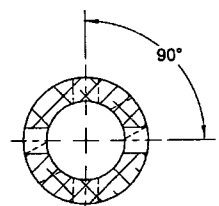
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CHECKED		DRAWING NO.	REV. B
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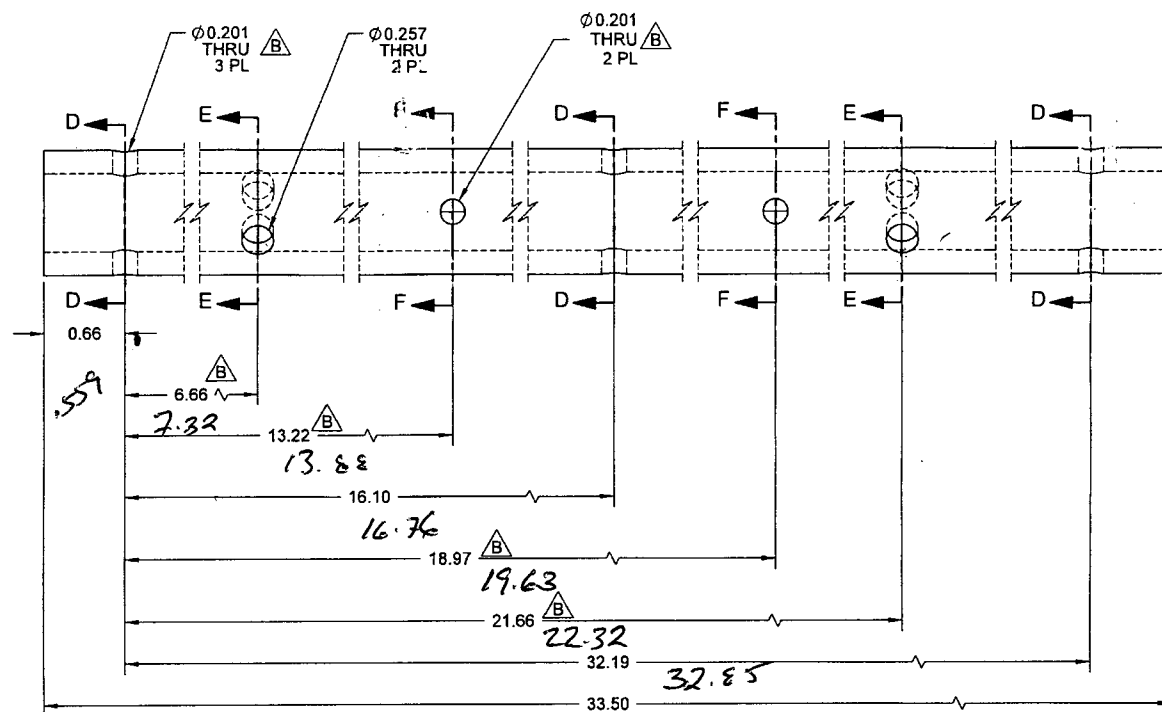
SECTION D-D



SECTION E-E



SECTION F-F



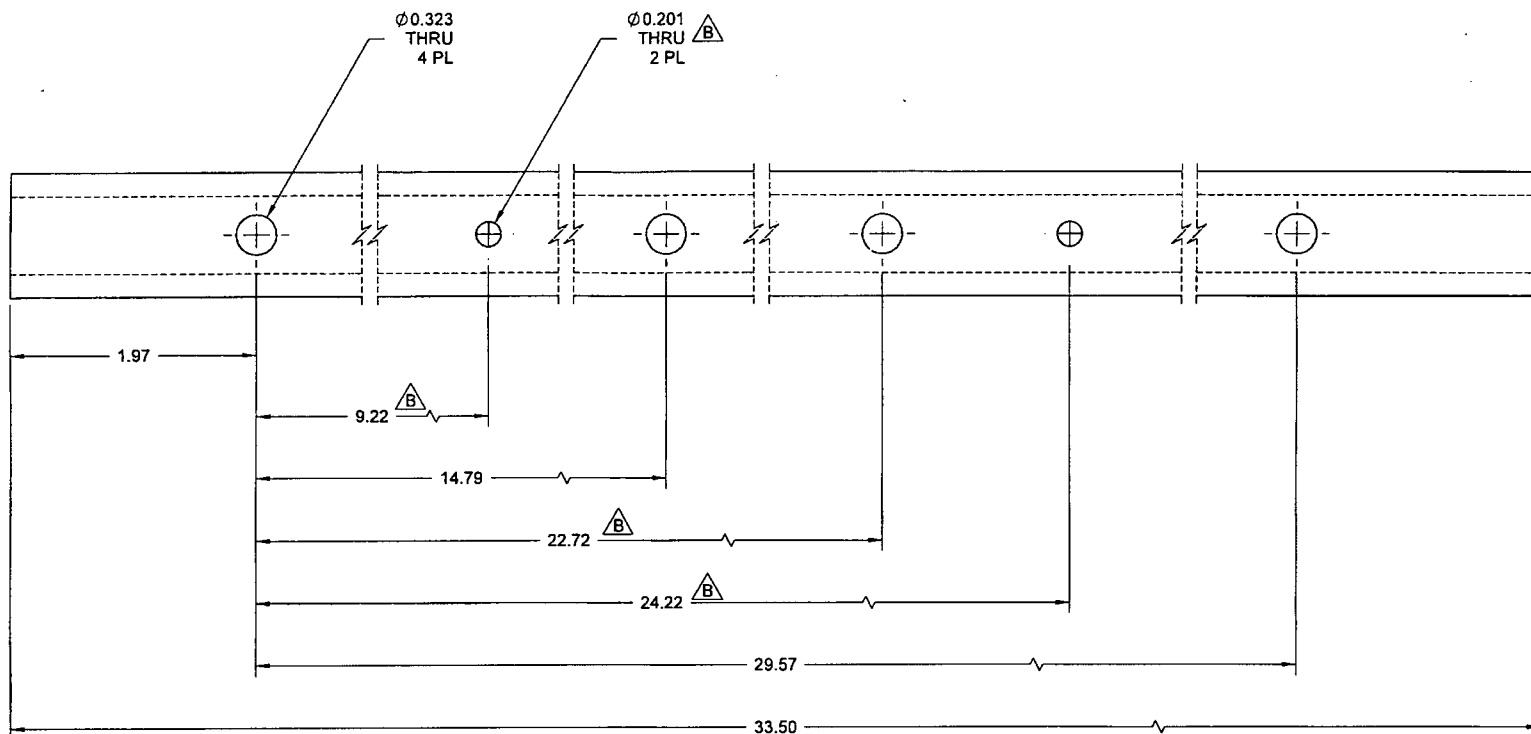
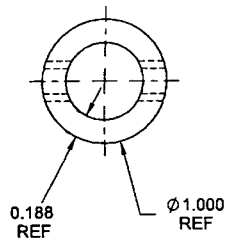
D3766-2 FRONT RAIL, RH

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08-07-10 MP

W/0 54382

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8 7 6 5 4 3 2 1



D3766-3 REAR RAIL

W/O 54382

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DRAWN	HS	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3766 REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE RAIL SCALE NTS
DE APPR.	<i>[Signature]</i>	
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